

Order 7019

7003+



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

648.4704

Job Sheet 180408



005170

Part No: 648.4704

Job Qty: 1 ea

Part Name: C45 Overhaul



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No:

Due Date: 8/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG OM & OOPM-C45 Rev 4 (648.4704) IPP Rev A 18.04.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/7/18	8/7/18	0.00	0.00	Start Up Small Fab-3		
100	Small Fab	1 pcs	8/7/18	8/7/18	0.00	1.00	Small Fab-3		
120	QC	1 pcs	8/7/18	8/7/18	0.00	0.00	QC4		
121	DC	1 pcs	8/7/18	8/7/18	0.00	0.00	DC		
130	Packaging	1 pcs	8/7/18	8/7/18	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea	8/7/18	8/7/18	0.00	0.00	QC21		

Part Op 100 - Pick bag and tag

Descriptions: 121 - Supply owner's & overhaul procedures manual

Y.A sold

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
NAS1149F0463P	Washer ✓	3 Ea (3 ea)	90-Start up Operation	5056461
NAS1149F0563P	Washer ✓	8 Ea (8 ea)	90-Start up Operation	5067901-1
188-FPSS-1/4 20-3/8	see P/N 188-FPSS-1/4-20-3/8 ✓	2 Ea (2 ea)	100-Small Fab	5075264
188-FSCS-1032-5/8	Screw ✓	4 Ea (4 ea)	100-Small Fab	5066767
600.1309-A	Label	1 Ea (1 ea)	100-Small Fab	
600.1312	Caution Sticker ✓	1 Ea (1 ea)	100-Small Fab	5072105
AN4-23A	Bolt ✓	2 Ea (2 ea)	100-Small Fab	507161378
AN5-21A	Bolt ✓	4 Ea (4 ea)	100-Small Fab	5071611
C2-14-2	Label Rivets ✓	2 Ea (2 ea)	100-Small Fab	5057170
C45-10-1 P	Spring Pin ✓	1 Ea (1 ea)	100-Small Fab	5029293
C45-10-2	Lock Spring ✓	1 Ea (1 ea)	100-Small Fab	5048693
C45-11-2 P	Locating Pin ✓	2 Ea (2 ea)	100-Small Fab	5029297
C45-12-1	Lock Bushing ✓	2 Ea (2 ea)	100-Small Fab	5091795
C45-12-6	Retaining Ring ✓	2 Ea (2 ea)	100-Small Fab	5088946
C45-13-1	Keeper Bushing ✓	2 Ea (2 ea)	100-Small Fab	5101278
C45-13-2	Spacer ✓	2 Ea (2 ea)	100-Small Fab	5027246
C45-13-5	Keeper Spring ✓	1 Ea (1 ea)	100-Small Fab	5053218
C45-3-1 P	Radial Bearing ✓	2 Ea (2 ea)	100-Small Fab	50293PH
C45-3-12	DU Bearing ✓	1 Ea (1 ea)	100-Small Fab	5091768
C45-3-2-1	Snap Ring ✓	2 Ea (2 ea)	100-Small Fab	5093408
C45-3-4-1	Retaining Ring ✓	4 Ea (4 ea)	100-Small Fab	5068056
C45-3-5	Spacer ✓	2 Ea (2 ea)	100-Small Fab	5043615
C45-3-8A	Actuator Shaft Bushing ✓	1 Ea (1 ea)	100-Small Fab	5078570

F123434
40

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION ☐ Work ☐ Scrap ☐ Rework	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
		MRB (QSI042) Approval _____ _____ _____			
		Completed By _____ _____ _____			
		Lead hand / Supervisor Approval Verification _____ _____ _____			
		QC / QA Coordinator Approval _____ _____ _____			

Part: 448.4704
 Job No: 160408
 Serial No/Batch: S105319
 Revision: 4
 Insp: 101
 Exp Date:
 Instructions:

Date: 08/27/10

DART I
 AEROSPACE
 Container No: S105319
 Part: 448.4704
 Job No: 160408
 Serial No/Batch: S105319
 Revision: 4
 Insp: 101
 Exp Date:
 Instructions:

Date: 08/27/10

12111 Aero - St Street
 Hawthorne, CA 90414
 TEL: 714 613 632 - 5200
 Email: sales@dartaero.com
 WWW.dartaerospace.com

Root Cause				CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Power Loss/Surge	☐
Design	☐	Operator	☐	Bending	☐	Folio/Program	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	Grain	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Weld	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Wrong Stock Pulled	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Out of Sequence	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Off-set	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Mislabeled	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Fit/Function	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Misaligned/off center	☐
Past Expiry Date	☐	Manufacturing Process	☐				
Misidentified	☐	Past Due	☐	OTHER :			

C45-3-8B	Actuator Shaft Bushing	1 Ea (1 ea)	100-Small Fab
C45-3-9	Lever Spring	1 pcs (1 ea)	100-Small Fab
C45-4-1	Trunnion Bushing	2 Ea (2 ea)	100-Small Fab
C45-5-1	Lever Stop Pin	1 Ea (1 ea)	100-Small Fab
C45-7-1	LOADBEAM BUMPER	1 Ea (1 ea)	100-Small Fab
C45-7-2	Lock Bumper	2 Ea (2 ea)	100-Small Fab
C45-8-4	Solenoid Cover Gasket	1 Ea (1 ea)	100-Small Fab
MS21044N5	Nut	4 Ea (4 ea)	100-Small Fab
MS27039-4-08	Screw	1 Ea (1 ea)	100-Small Fab

5078801
 5089520
 5078803
 5029329
 5029332
 5095587 5095587 TX
 5094821
 5076821 v2
 5039330
 Em129624-40
 x2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	NAS1149F0463P	3	747	0
	NAS1149F0563P	8	626	0
100-Small Fab	188-FPSS-1/4 20-3/8	2	0	0
	188-FSCS-1032-5/8	4	377	0
	600.1309-A	1	0	0
	600.1312	1	22	0
	AN4-23A	2	588	0
	AN5-21A	4	73	0
	C2-14-2	2	206	0
	C45-10-1	1	91	0
	C45-10-2	1	11	0
	C45-11-2	2	78	0
	C45-12-1	2	16	0
	C45-12-6	2	84	0
	C45-13-1	2	13	0
	C45-13-2	2	82	0
	C45-13-5	1	95	0
	C45-3-1	2	18	0
	C45-3-12	1	12	0
	C45-3-2-1	2	54	0
	C45-3-4-1	4	156	0
	C45-3-5	2	78	0
	C45-3-8A	1	57	0
	C45-3-8B	1	38	0
	C45-3-9	1	0	0
	C45-4-1	2	48	0
	C45-5-1	1	41	0
	C45-7-1	1	0	0
	C45-7-2	2	12	0
	C45-8-4	1	0	0
	MS21044N5	4	139	0
	MS27039-4-08	1	78	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																
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